

## Chatter Free End Mill D16mm

A01-010

Chatter Free End Mill in carbide with diameter 16mm, cutting edge length 35mm, 4 flutes, 2 center cutting, helix angle 35 / 38° and individual division. Flute has been ground from solid in one pass. First clearance with CAM and second with recess.



### 1. Cycletime for Production

Workpiece: Ø16 L25, Z4 / Z2 Material CARBIDE								
Operations	prob	flute	OD 2	gash	end 2	end 1	chamfer	OD 1
Feed [mm/Min]	2000	50	150	20	100	100	500	100
Power [kW]	0	2	1	1	1	1	1	1
Cutting speed [m/s]	0	18	18	22	22	22	22	18
Used wheels		1	1	3	2	2	2	1
Grinding time [s]	20	310	55	95	42	38	20	148
Total cycle time	12min 08s							

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

1	1A1 Ø125 D76
1	11V9 Ø100 D76
1	12V9 Ø125 D64



### 3. Machine and Software Requirements

Machines: ariesNGP

Control: Fanuc 3x

Accessories:

Responsible engineer: MAM, 19.08.16

Coolant: Synthetic Oil, pressure 5 bar

Software: Quinto 5

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